

S 151154



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D5483-041
Job Sheet 188022-A

**Part No:** D5483-041**Job Qty:** 14 pcs**Part Name:** Tow Cap Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/6/19**Job Tracking No:****Due Date:** 2/20/19**Created By:** Jason Leroux**Type:** Stock**Description:**

Note: D5483 REV:B IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.03 AS PER DWG REV.A DD
VERF:DP IPP REV:C AS PER DWG REV.B JFS 18.10.05 VERIFIED BY:DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	14 pcs		2/20/19	0.00	0.00	Bandsaw - 1		JF 19-02-06
110	HAAS 5 Axis - B4B	14 pcs		2/20/19	0.00	9.30	HAAS - 5 - B4B		JF 19-05-04
115	QC 2	14 pcs		2/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		JF 19-05-04
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		

**Container No:** S151154**Part:** D5483 - 041**Job No:** 188022 - A**Serial No/Batch:** S150717**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/06/19

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120 QC 8	14 pcs	2/20/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67 QC 8 - 23	VHJ 19/5/5
				QC 8 - 1 (A)	
				QC 8 - 47	
130 Handfinish - 1-1 Chemical-B4B	14 pcs	2/20/19	0.00 0.00	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	

				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
135 QC 7	14 pcs	2/20/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	DAS
				QC 7 - 48	58
				QC 7 - 51	9-89 MAY 06 2019
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	DAS
140 Small Fab - 2 - B4B	14 pcs	2/20/19	0.00 3.50	Small Fab - 1 - B4B	58 MAY 06 2019
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	14 pcs	2/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	DAS
				QC 5 - 50	40 MAY 07 2019 9-89
				QC 5 - 30	

160 Powdercoat - 1 White Gl(A)- B4B	14 pcs	2/20/19	0.00 3.50	Powdercoat - 1 - B4B	
M 151749.				Powdercoat - 2 - B4B	
START 2:15 O.T. 320° FINISH 2:45				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	BL 19-5-7
170 QC 3	14 pcs	2/20/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
180 Packaging 3-1 - Stock - B4B	14 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001 M 19-5-9
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

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MAY 07 2019 40
9-89

190 QC 21 - SA		14 pcs	2/20/19	0.00 0.00	Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	21
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part Op 100 - CUT BLANK AT 4.200"

Descriptions: 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FC024. DWG REV: B FOLIO REV: AA 2-
 Debur and break all sharp edges. 3- Check hole alignment as per note8
 115 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 135 - (QC7-Inspect Chemical Conversion Coat)
 140 - Install nut plates as per dwg
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***HAND TIGHT A SCREW IN THE NUTPLATE PRIOR TO
 POWDERCOAT*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.750	6061-T6 Round Bar 3.750"	4.9000 ft (.35 ea)	100-Bandsaw - 1	5070816
CCR264SS-3-03	Cherry Rivet	112 Ea (8 ea)	140-Small Fab - 2 - B4B	
MS21075L3N	Nut Plate	56 Ea (4 ea)	140-Small Fab - 2 - B4B	5143492 x44

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6R3.750	5	6	0
140-Small Fab - 2 - B4B	CCR264SS-3-03	112	402	0
	MS21075L3N	56	137	0

Part Specifications	
Specifications could not be found.	

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